



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3610-041
Job Sheet 209003



Part No: D3610-041

Job Qty: 6 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/8/20

Job Tracking No:

Due Date: 5/20/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3610 REV B IPP rev A new issue 07.03.28 EC IPP rev B released, changed mat'l EC IPP REV C:AS
PER REV B JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		5/19/20	0.00	0.21	Bandsaw - 1		K8 20/05/27
110	HAAS 4 Axis - B4B	6 pcs		5/19/20	0.39	7.32	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		K8 20/05/27
120	QC 2	6 pcs		5/19/20	0.00	0.00	QC 2 - 1		K8 20/05/27
							QC 2 - 12		K8 20/05/27
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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Container No: S279752



Part: D3610-041

Job No: 209003

Serial No/Batch: S279752

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/27/20

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4/8/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

130 QC 8	6 pcs	5/19/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 8 - 12	
				QC 8 - 14	mk 20/05/28
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
140 Small Fab - 2 - B4B	6 pcs	5/19/20	0.00 0.25	Small Fab - 1 - B4B	mk 20/05/28
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
150 QC 5	6 pcs	5/19/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	

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						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
							DAS MAY 28 2020 40 9-89
160	M 138839. Powdercoat - 3 Grey Sand - B4B	6 pcs	5/19/20	0.00	0.11	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
170	START 11:00 OUT 3:00 PM FINISH 11:30 QC 3	6 pcs	5/19/20	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
						QC 3 - 87	
180	Small Fab - 3 - B4B	6 pcs	5/20/20	0.00	0.25	Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						Small Fab - 8 - B4B	
						Small Fab - 9 - B4B	
						Small Fab - Various 1 - B4B	
190	QC 5	6 pcs	5/20/20	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	

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				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
200	Packaging 3-1 - Stock - B4B	6 pcs	5/20/20	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
210	QC 21 - SA	6 pcs	5/20/20	0.00 0.00	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - (Bandsaw) Cut blank 7.900 " long
 Descriptions: **110** - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: B 2-Deburr per dwg D3610
120 - QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Small Fab) 1-C'SINK AS PER DWG D3610
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Rivet Nut Plate as per Dwg D3610
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140N-B1.500X1.5000	4140 Steel Bar 1.50 X 1.50	3.9000 ft (.65 ea)	100-Bandsaw - 1	S278360
MS20426AD3-4	Rivet	12 Ea (2 ea)	180-Small Fab - 3 - B4B	fm136444-2
MS21075L3	Nut Plate	6 Ea (1 ea)	180-Small Fab - 3 - B4B	SO 489107

CA1056
ST298

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M4140N-B1.500X1.5000	4	0	0
180-Small Fab - 3 - B4B	MS20426AD3-4	12	1,196	0
	MS21075L3	6	178	0

Part Specifications

Specifications could not be found.

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7.9" X 6

M4130N-B1.500X1.500
S278360

DART AEROSPACE LTD		Work Order:	209003
Description: Plate		Part Number:	D3610-1
Inspection Dwg: D3610 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.250	✓		Kt-05	vern.
0.250	+/-0.010	0.250	✓		" "	"
0.63	+/-0.030	0.625	✓		" "	"
7.75	+/-0.030	7.753	✓		31006	H-G
4.25	+/-0.030	4.250	✓		"	"
2.677	+/-0.010	2.677	✓		Kt-05	vern.
0.38	+/-0.030	0.375	✓		" "	"
Ø0.277	+0.006/-0.001	0.277	✓		" "	"
Ø0.201	+0.005/-0.001	0.201	✓		" "	"
Ø0.098	+0.004/-0.001	0.098	✓		" "	"
0.88	+/-0.030	0.884	✓		31006	H-G
0.94 x 0.50	+/-0.030	0.937 x 0.500	✓		Kt-05	vern.
0.250	+/-0.010	0.254	✓		"	"
0.125 depth	+/-0.010	0.124	✓		"	"

Measured by: <i>KJ</i>	Audited by: <i>AK</i>	Preliminary Approval:
Date: 20-05-27	Date: 20/05/28	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue P/O D3610-041	KJ/DD	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	<i>[Signature]</i>



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐
		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐
		Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐
Date: _____		Sequence #: _____		QTY Affected: _____	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
		MRB (QSI042)			
Root Cause		FAULT CATEGORY			
Operator ☐		Contamination ☐		Power Loss/Surge ☐	
Manufacturing Process ☐		Misaligned/off center ☐		Folio/Program ☐	
Equip/Tooling ☐		BOM/Route ☐		Grain Direction ☐	
Handling/Preservation ☐		Broken/Damage/Defect ☐		Weld ☐	
Material ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
Product Improvement ☐		Drill Holes ☐		Out of Sequence ☐	
Process Improvement ☐		Fit/Function ☐		Off-set/Set-up ☐	
Human Factors ☐		Other/Details: _____		Positioned Wrong ☐	
				Outside Tolerance ☐	
				Drawing ☐	
				Finish ☐	
				Part Lost/Missing ☐	
				Misread ☐	